

slip oct 15

Date: Friday, 9/21/2007 1:05:01 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : GPS RECEIVER HOUSING
Job Number : 34800
Estimate Number : 12517
P.O. Number : N/A Part Number : D3514047
This Issue : 9/21/2007 S.O. No. : N/A Drawing Number : UNDER REVIEW D3514
Prsht Rev. : NC Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB Drawing Revision : N/A A 10/09/24
Previous Run : 33292 Material : N/A
Written By : Due Date : 10/12/2007 Qty: 5 Um: Each
Checked & Approved By :
Comment : Est Rev:A New Issue 07-05-28 EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D35143 BOX TOP (TOP MOUNTED)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
BOX TOP (BOTTOM MOUNTED)
Batch: B 34821

2.0 D35147 BOX BOTTOM (TOP MOUNTED)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
BOX BOTTOM (BOTTOM MOUNTED)
Batch: B 34822

3.0 D35149 HOOD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
HOOD
Batch: 34823

4.0 D3524041 UPPER AND LOWER PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
UPPER AND LOWER PLATE
Batch: 34824

5.0 MS20426AD3 RIVET



Comment: Qty.: 8.0000 Each(s)/Unit Total : 40.0000 Each(s)
RIVET
Batch: M1563

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
27/10/12	9	Split W/O	ES	27/10/12	4			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 9/21/2007 1:05:01 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GPS RECEIVER HOUSING

Job Number: 34800

Part Number: D3514047

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

MS20426AD44

Rivet



Comment: Qty.: 11.0000 Each(s)/Unit Total : 55.0000 Each(s)

Rivet

Batch: M1021

CB

7.0

MS20426AD49

RIVET



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

RIVET

Batch: M18136

CB

8.0

MS21072L06

ANCHOR NUT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

ANCHOR NUT

Batch: M101760

CB 7/9/11

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D3514

mf 07-10-12 (4)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

1 SB 07/10/12

11.0

POWDER COATING

POWDER COATING



M102316



(4x)

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

m-l 07/10/12

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

mf 07-10-13 (4)

13.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble trim as per dwg D3514

mf 07-10-15 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DD Date: 07/10/15
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 9/21/2007 1:05:01 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GPS RECEIVER HOUSING

Job Number: 34800

Part Number: D3514047

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

D35261

RUBBER SEAL



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

RUBBER SEAL

B 34825 MF 07-10-15

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/10/15

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: GA

SB 07/10/15

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

SB 07/10/15

Job Completion



U 07-10-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

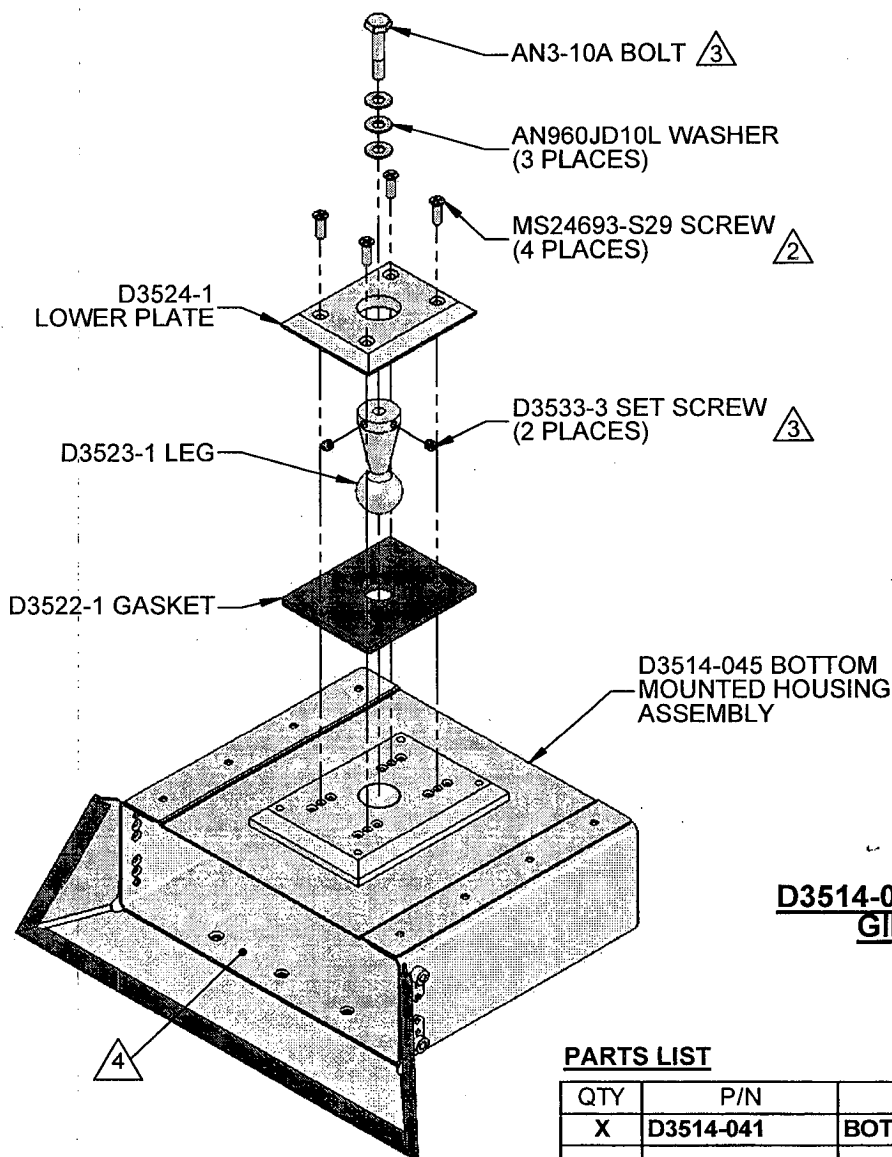
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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CHECKED LE	APPROVED [Signature]	DRAWING NO. D3514	REV. A SHEET 1 OF 9
DATE 07.06.18		TITLE GPS RECEIVER HOUSING	SCALE 1:3
REV A	DATE 07.06.18	DESCRIPTION NEW ISSUE	



RELEASED
07.08.03

**D3514-041 BOTTOM MOUNTED
GIMBAL ASSEMBLY**

PARTS LIST

QTY	P/N	DESCRIPTION
X	D3514-041	BOTTOM MOUNTED GIMBAL ASSEMBLY
1	D3514-045	BOTTOM MOUNTED HOUSING ASSEMBLY
1	D3522-1	GASKET
1	D3523-1	LEG
1	D3524-1	LOWER PLATE
2	D3533-3	SET SCREW
1	AN3-10A	BOLT
3	AN960JD10L	WASHER
4	MS24693-S29	SCREW

NOTE:

- 1) ASSEMBLE PER DART QSI 003
- 2) TORQUE SCREWS TO 5-6 in-lbs
- 3) TIGHTEN TO SNUG FIT ONLY
- 4) IDENTIFY WITH DART P/N "D3514-041" USING A WHITE MARKER ON THE INSIDE OF THE HOUSING ASSEMBLY WHERE INDICATED

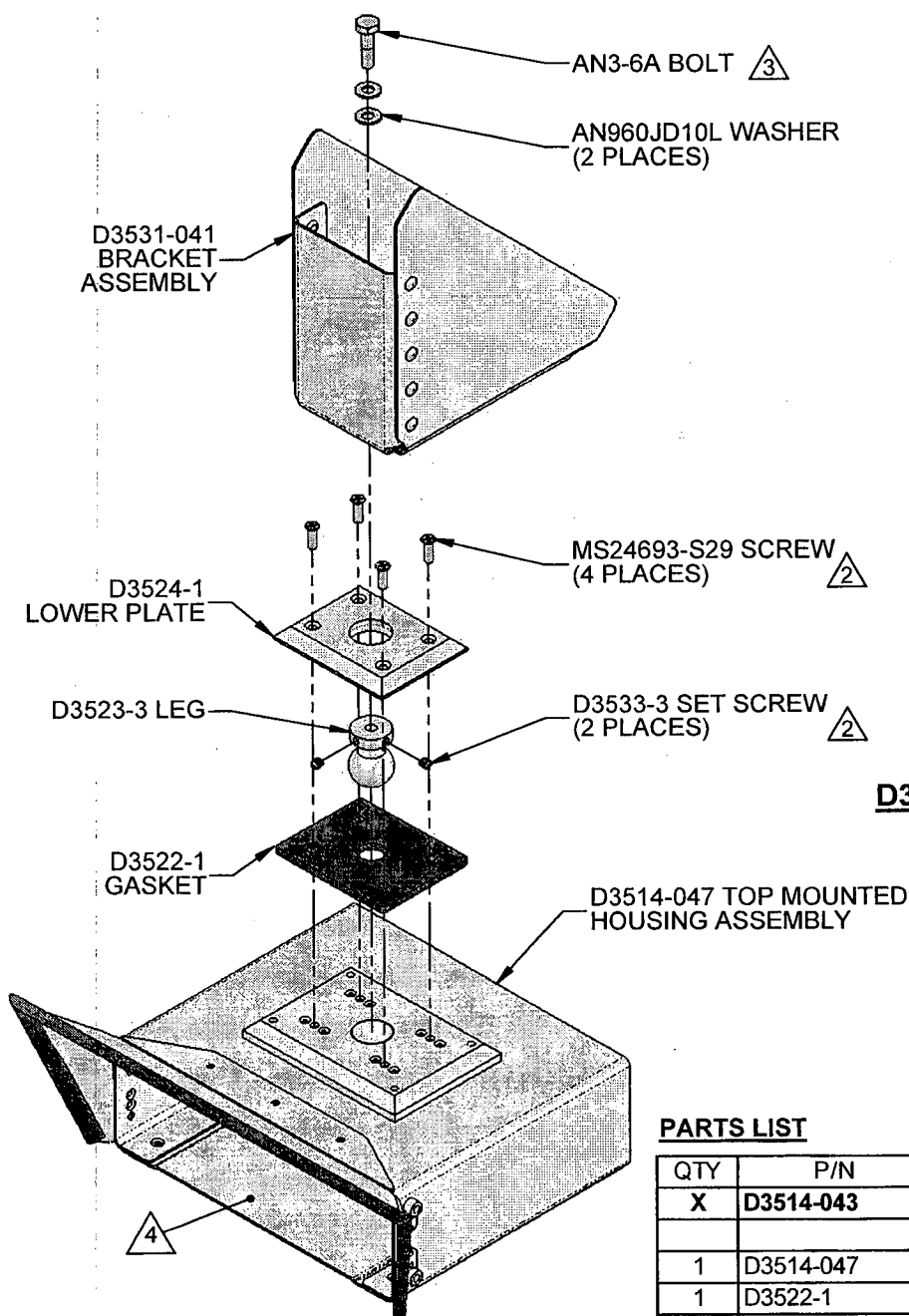
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DATE 07.06.18	TITLE GPS RECEIVER HOUSING	REV. A SHEET 2 OF 9 SCALE 1:3

RELEASED
07.08.03



D3514-043 TOP MOUNTED GIMBAL ASSEMBLY

PARTS LIST

QTY	P/N	DESCRIPTION
X	D3514-043	TOP MOUNTED GIMBAL ASSEMBLY
1	D3514-047	TOP MOUNTED HOUSING ASSEMBLY
1	D3522-1	GASKET
1	D3523-3	LEG
1	D3524-1	LOWER PLATE
1	D3531-041	BRACKET ASSEMBLY
2	D3533-3	SET SCREW
1	AN3-6A	BOLT
2	AN960JD10L	WASHER
4	MS24693-S29	SCREW

NOTE:

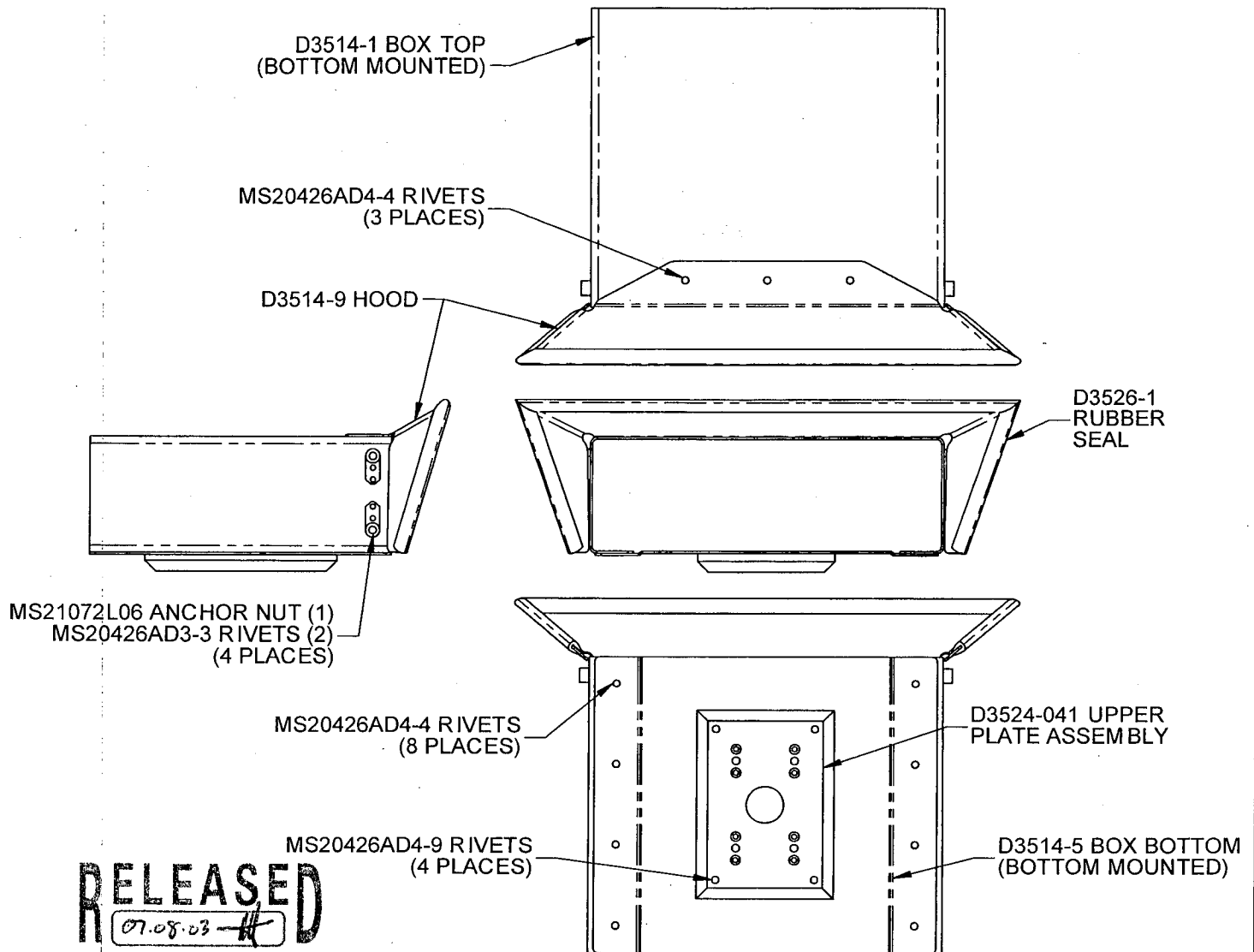
- 1) ASSEMBLE PER DART QSI 003
- 2) TORQUE SCREWS TO 5-6 in-lbs
- 3) TORQUE BOLTS TO 15-25 in-lbs
- 4) IDENTIFY WITH DART P/N "D3514-043" USING A WHITE MARKER ON THE INSIDE OF THE HOUSING ASSEMBLY WHERE INDICATED

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DATE 07.06.18		TITLE GPS RECEIVER HOUSING	SCALE 1:3



RELEASED
07.08.03 **#**

D3514-045 BOTTOM MOUNTED HOUSING ASSEMBLY

NOTES:

- 1) POWDER COAT ASSEMBLY BLACK
SANDTEX (4.3.5.7) PER DART QSI 005 4.3.
- 2) ASSEMBLE PER DART QSI 003

PARTS LIST

QTY	P/N	DESCRIPTION
X	D3514-045	BOTTOM MOUNTED HOUSING ASSEMBLY
1	D3514-1	BOX TOP (BOTTOM MOUNTED)
1	D3514-5	BOX BOTTOM (BOTTOM MOUNTED)
1	D3514-9	HOOD
1	D3524-041	UPPER PLATE ASSEMBLY
1	D3526-1	RUBBER SEAL
8	MS20426AD3-3	RIVET
11	MS20426AD4-4	RIVET
4	MS20426AD4-9	RIVET
4	MS21072L06	ANCHOR NUT

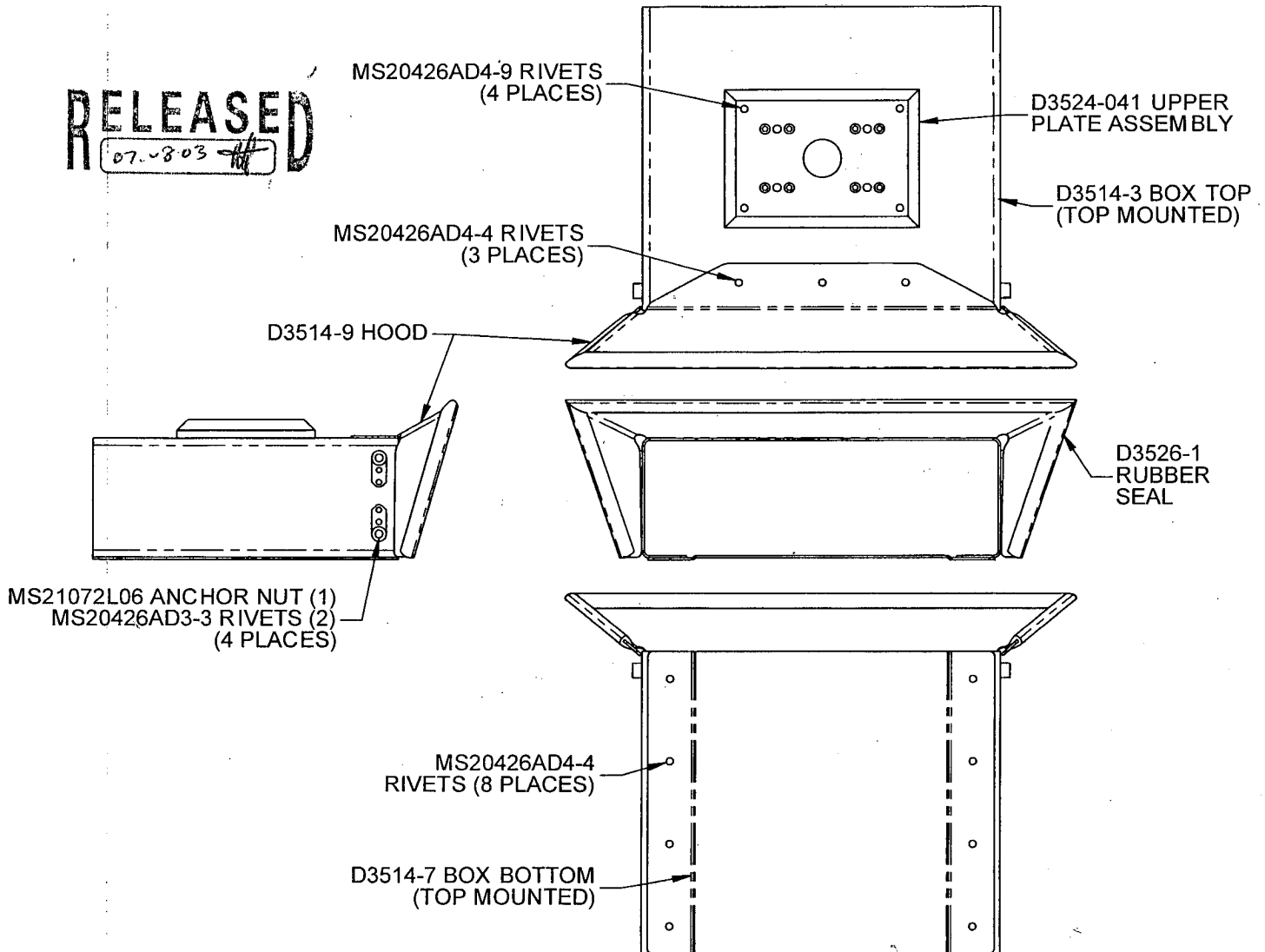
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DATE 07.06.18		TITLE GPS RECEIVER HOUSING	SCALE 1:3

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07.08.03



D3514-047 TOP MOUNTED HOUSING ASSEMBLY

NOTES:

- POWDER COAT ASSEMBLY BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3.
- ASSEMBLE PER DART QSI 003

PARTS LIST

QTY	P/N	DESCRIPTION
X	D3514-047	TOP MOUNTED HOUSING ASSEMBLY
1	D3514-3	BOX TOP (TOP MOUNTED)
1	D3514-7	BOX BOTTOM (TOP MOUNTED)
1	D3514-9	HOOD
1	D3524-041	UPPER PLATE ASSEMBLY
1	D3526-1	RUBBER SEAL
8	MS20426AD3-3	RIVET
11	MS20426AD4-4	RIVET
4	MS20426AD4-9	RIVET
4	MS21072L06	ANCHOR NUT

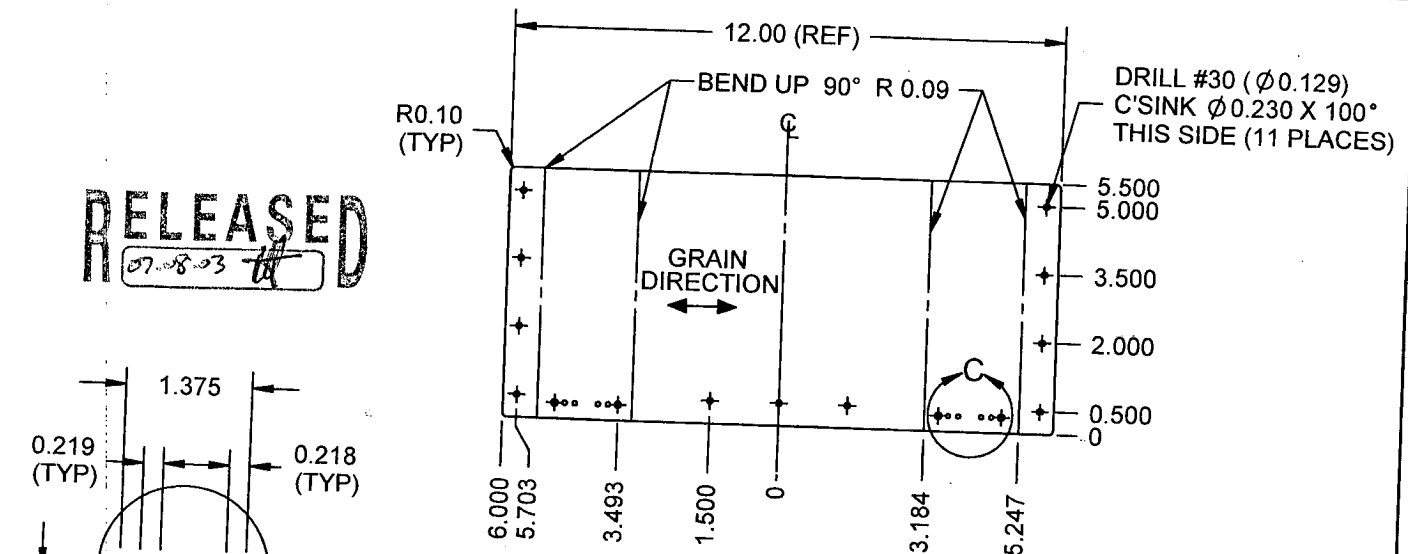
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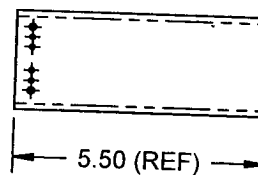
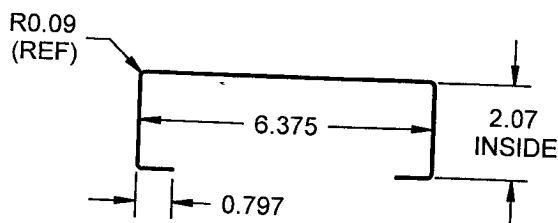
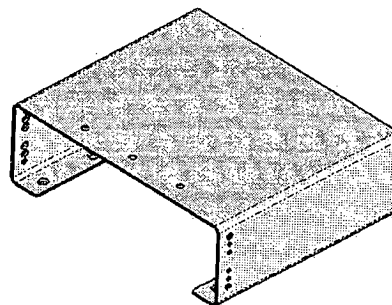


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DATE 07.06.18	TITLE GPS RECEIVER HOUSING	REV. A SHEET 5 OF 9 SCALE 1:4

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**D3514-1F
FLAT PATTERN**



D3514-1 BOX TOP (BOTTOM MOUNTED)

NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT C
- 7) C'SINKS ARE ON THE INSIDE OF PART (AFTER BENDING)

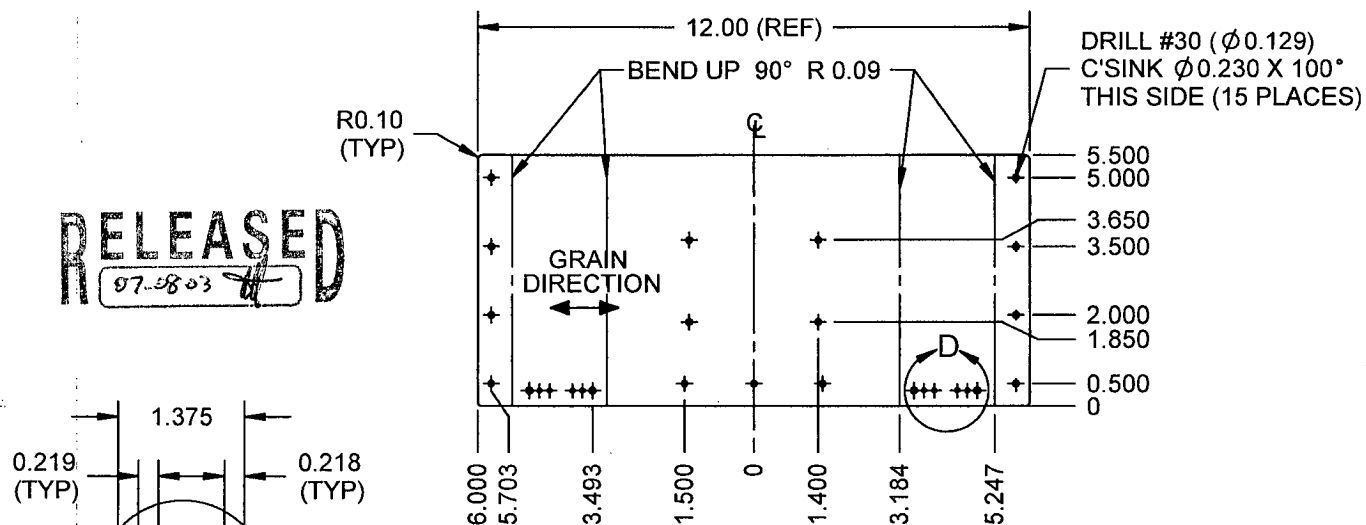
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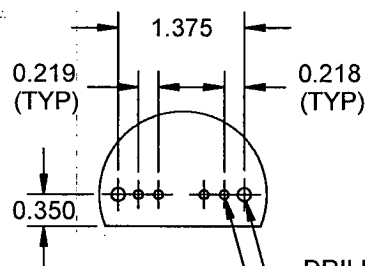
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DATE 07.06.18		TITLE GPS RECEIVER HOUSING SCALE 1:4	

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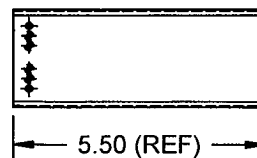
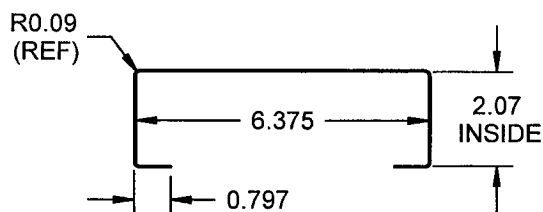
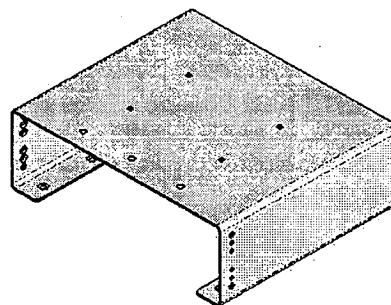
D3514-3F
FLAT PATTERN



DETAIL D
SCALE 1:2

DRILL #27 (Ø0.144)
(4 PLACES)

DRILL #40 (ϕ 0.098)
C'SINK ϕ 0.182 X 100° THIS SIDE
(8 PLACES) FOR RIVETS



D3514-3 BOX TOP (TOP MOUNTED)

NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT ϕ
- 7) C'SINKS ARE ON THE INSIDE OF PART (AFTER BENDING)

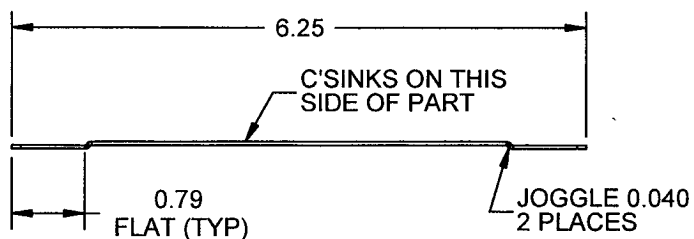
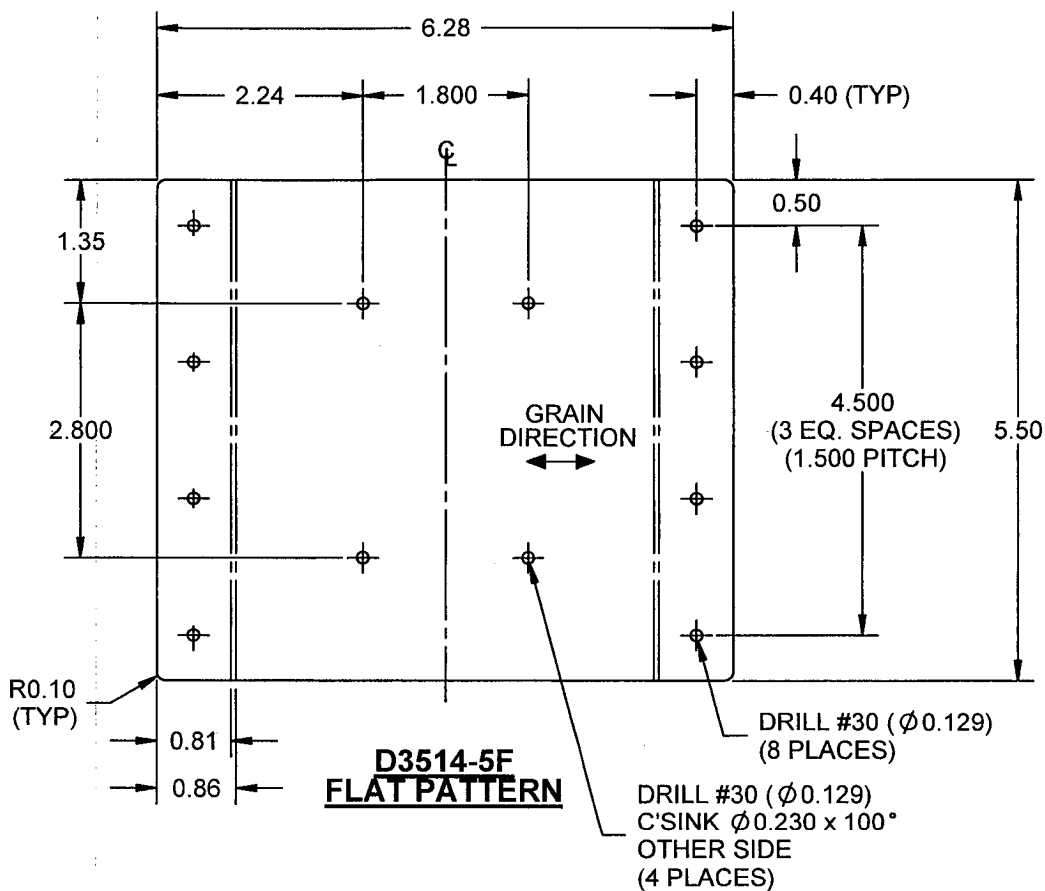
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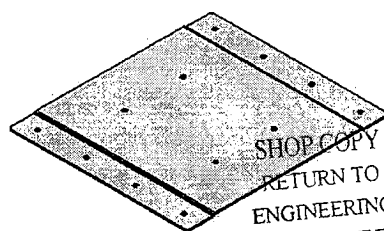
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DATE 07.06.18		TITLE GPS RECEIVER HOUSING	SCALE 1:2



D3514-5 BOX BOTTOM (BOTTOM MOUNTED)

NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT ϕ
- 7) C'SINK ABOVE JOGGLE



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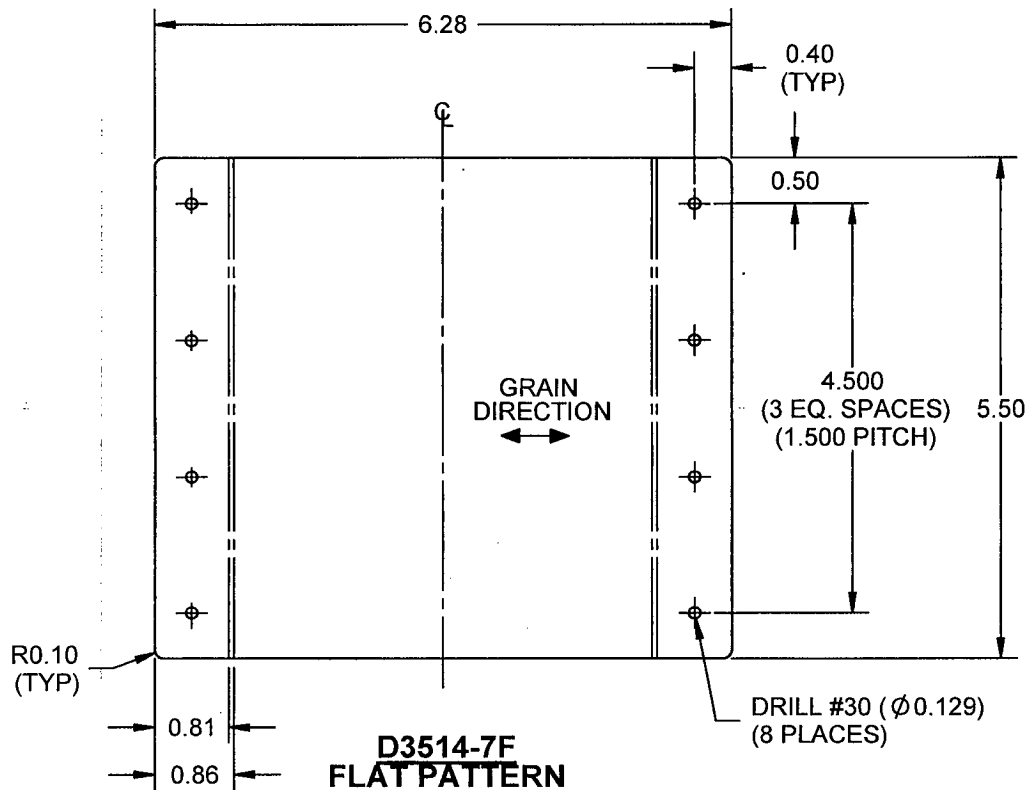
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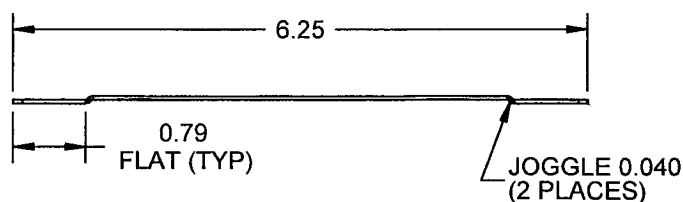
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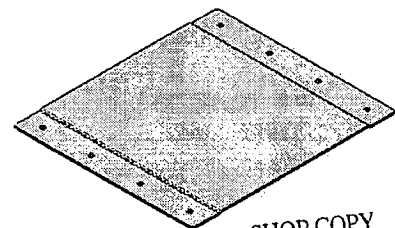
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DATE 07.06.18		TITLE GPS RECEIVER HOUSING	SCALE 1:2



**D3514-7F
FLAT PATTERN**



D3514-7 BOX BOTTOM (TOP MOUNTED)



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NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT C

NO. _____

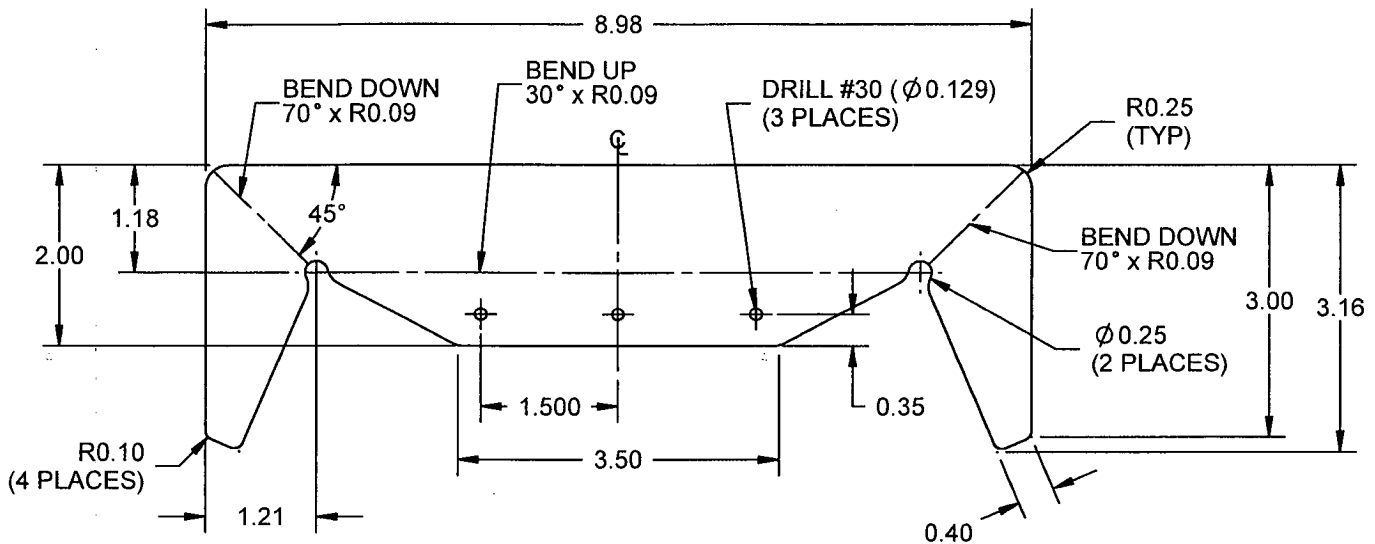
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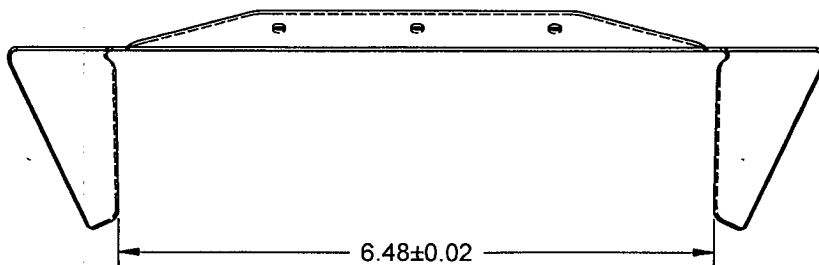
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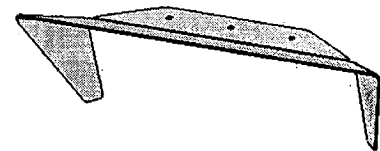
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DATE 07.06.18		TITLE GPS RECEIVER HOUSING	SCALE 1:2



**D3514-9F
FLAT PATTERN**



FRONT VIEW



D3514-9 HOOD

NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT ϕ

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